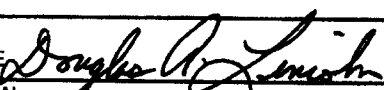


ENGINEERING CHANGE PROPOSAL (ECP), PAGE 1				1. DATE (YYMMDD) 20021210		Form Approved OMB No. 0704-0188	
Public reporting burden for this collection of information is estimated to average 2 hours per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing this burden, to Department of Defense, Washington Headquarters Services, Directorate for Information Operations and Reports, 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302, and to the Office of Management and Budget, Paperwork Reduction Project (0704-0188) Washington, DC 20503.							
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						3. DODAAC	
4. ORIGINATOR a. TYPED NAME (First, Middle Initial, Last) <b>Douglas A. Lincoln</b>		b. ADDRESS (Street, City, State, Zip Code) <b>TACOM-ARDEC, AMSTA-AR-FSA-RF ROCK ISLAND, IL. 61299-7300</b>		5. CLASS OF ECP <b>I</b>			
8. ECP DESIGNATION a. MODEL/TYPE <b>M67</b>		b. CAGE CODE <b>19200</b>		c. SYSTEM DESIGNATION <b>M67 GRENADE &amp; M213/M228 FUZE</b>		9. BASELINE AFFECTED FUNCTIONAL <input checked="" type="checkbox"/> PRODUCT ALLOCATED <input type="checkbox"/>	
d. ECP NO. <b>DL2002345</b>		e. TYPE <b>F</b>		f. REV		10. OTHER SYS./CONFIG. ITEMS AFFECTED YES <input type="checkbox"/> NO <input checked="" type="checkbox"/>	
11. SPECIFICATIONS AFFECTED				12. DRAWINGS AFFECTED			
	CAGE Code	Specification/Document No.	Rev.	SCN	CAGE Code	Number	Rev.
a. SYSTEM		<b>MIL-G-14933A Amd 3</b>			<b>8822131</b>		
b. DEVELOPMENT		<b>DTL9235210</b>			<b>9235210</b>		
c. PRODUCT		<b>DTL8822131</b>					
13. TITLE OF CHANGE <b>Update Fuze and Grenade documents to reflect latest requirements and implementation of new AXI X-Ray equipment at MEI.</b>							
14. CONTRACT NO. LINE ITEM <b>DAAA09-02-C-0012 &amp; DAAA09-99-G-0004 DO0022</b>				15. PROCURING CONTRACTING OFFICER a. NAME (First, Middle Initial, Last) <b>Melanie Johnson &amp; Gene Harrison</b> b. CODE c. TELEPHONE NO. EXT 23815 & 23191			
16. CONFIGURATION ITEM NOMENCLATURE <b>GRENADE ASSY M67 &amp; M213/M228 Fuze</b>						17. IN PRODUCTION X YES <input type="checkbox"/> NO	
18. ALL LOWER LEVEL ITEMS AFFECTED							
a. NOMENCLATURE <b>GRENADE ASSY M67 &amp; M213/M228 Fuze</b>				b. PART NO. <b>MIL-G-14933</b>		c. NSN	
19. DESCRIPTION OF CHANGE <b>Change Delay composition delay time FROM: 5.5 +/- .5 TO: 5.5 to 6.2. Added to DTLs and MILSPEC the definition of a void by describing an acceptable minimum size which does not allow the fuze delay time to go below the safe time of 4.0 seconds.</b>							
20. NEED FOR CHANGE <b>This change allows for the use of new automatic Digital X-Ray inspection equipment produced by AXI and installed at MEI. The equipment detects casting voids presence in the zinc body, normally up to .03" in diameter, that was previously not detectable. Without some allowable void size, all product manufactured by MEI would be rejected. Phase I and II testing and testing at AXI, performed in partnership between MEI and the Government was utilized to arrive at this new void size standard. (For further detail see attached reports.)</b>							
21. PRODUCTION EFFECTIVITY BY SERIAL NUMBER <b>N/A</b>				22. EFFECT ON PRODUCTION DELIVERY SCHEDULE <b>N/A</b>			
23. RETROFIT							
a. RECOMMENDED ITEM EFFECTIVITY <b>N/A</b>				b. SHIP / VEHICLE CLASS AFFECTED <b>N/A</b>			
c. ESTIMATED KIT DELIVERY SCHEDULE <b>N/A</b>				d. LOCATIONS OR SHIP / VEHICLE NUMBERS AFFECTED <b>N/A</b>			
24. ESTIMATED COSTS / SAVINGS UNDER CONTRACT <b>N/A</b>				25. ESTIMATED NET TOTAL COSTS / SAVINGS <b>N/A</b>			
26. SUBMITTING ACTIVITY a. AUTHORIZED SIGNATURE 				b. TITLE <b>ELECTRONICS ENGINEER</b>			
27. APPROVAL / DISAPPROVAL							
a. CLASS I <input type="checkbox"/> APPROVAL RECOMMENDED <input type="checkbox"/> DISAPPROVAL RECOMMENDED		b. CLASS II <input type="checkbox"/> APPROVED <input type="checkbox"/> DISAPPROVED		c. CLASS II <input type="checkbox"/> CONCUR IN CLASSIFICATION OF CHANGE <input type="checkbox"/> DO NOT CONCUR IN CLASSIFICATION OF CHANGE			
d. GOVERNMENT ACTIVITY <b>TACOM-ARDEC, Rock Island, IL. 61299-7300</b>				e. SIGNATURE		f. DATE SIGNED (YYMMDD)	
g. APPROVAL <input type="checkbox"/> APPROVED <input type="checkbox"/> DISAPPROVED		h. GOVERNMENT ACTIVITY		i. SIGNATURE		j. DATE SIGNED (YYMMDD)	

R263003

**NOR LIST**

DOCUMENT	NOR #
8822131	0001
9235210	0002
DTL 8822131	0003
DTL 9235210	0004
MIL-G-14933	0005

**REMARKS**

This Engineering Change Proposal (ECP) is written as a result of the Government's effort to replace the Nucleonics inspection equipment installed at Martin Electronics, Inc (MEI) with state-of-the-art digital X-Ray equipment. During the development and testing of this system events occurred that now require the drawings and specifications to change. The delay composition delay time needs to change From: "5.0 to 6.0 seconds per inch" To: "5.5 to 6.2 seconds per inch" because we are now going to have very small allowable voids and cracks in the delay composition, so the increase in time adds a safety factor to continue to keep the fuze delay time above 4.0 seconds. The AXI equipment readily found porosity in the fuze body castings between .02 to .03 inch diameter, therefore it was determined that the allowable void/crack size would need to be larger than .03 inch. So, the DTL's are adding both the definition of a not to exceed void/crack size and porosity in the castings otherwise all product manufactured by MEI would be rejected. This same definition additions are also added to this ECP so the acceptance criteria of the fuzes is the same prior to loading into an M67 Grenade. Several documents are included in this ECP to form a historical record of the recommended changes.

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		<b>5. CAGE CODE</b> <b>19200</b>	<b>6. NOR NO.</b> <b>0001</b>
		<b>7. CAGE CODE</b> <b>19200</b>	<b>8. DOCUMENT NO.</b> <b>8822131</b>
<b>9. TITLE OF DOCUMENT</b> <b>FUZE, HAND GRENADE M213 ASSEMBLY</b>		<b>10. REVISION LETTER</b> a. CURRENT <b>AA</b>	
		b. NEW	
<b>11. ECP NO.</b>			
<b>12. CONFIGURATION ITEM (OR SYSTEM) TO WHICH ECP APPLIES</b> <b>FUZE, HAND GRENADE M213 ASSEMBLY</b>			
<b>SHT 1 OF 1</b>			
<b>13. DESCRIPTION OF REVISION</b>  <b>ZONE A-8, NOTE 16, CHANGE:</b>  <b>FROM: "5.5 + OR - 0.5 SECONDS"</b>  <b>TO: "5.5 + 0.7 SECONDS"</b>			
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		f. DATE SIGNED (YYYYMMDD)	
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		<b>5. CAGE CODE</b> <b>19200</b>	<b>6. NOR NO.</b> <b>0002</b>			
		<b>7. CAGE CODE</b> <b>19200</b>	<b>8. DOCUMENT NO.</b> <b>9235210</b>			
<b>9. TITLE OF DOCUMENT</b> <b>FUZE, HAND GRENADE M228 ASSEMBLY</b>		<b>10. REVISION LETTER</b> a. CURRENT <b>M</b>				
		b. NEW				
<b>11. ECP NO.</b>						
<b>12. CONFIGURATION ITEM (OR SYSTEM) TO WHICH ECP APPLIES</b> <b>FUZE, HAND GRENADE M228 ASSEMBLY</b>						
<b>SHT 1 OF 1</b>						
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<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 10%;">a. (X one)</td> <td style="width: 10%; text-align: center;">X</td> <td style="width: 80%;">           (1) Existing document supplemented by this NOR may be used in manufacture.            (2) Revised document must be received before manufacturer may incorporate this change.            (3) Custodian of master document shall make above revision and furnish revised document.         </td> </tr> </table>				a. (X one)	X	(1) Existing document supplemented by this NOR may be used in manufacture. (2) Revised document must be received before manufacturer may incorporate this change. (3) Custodian of master document shall make above revision and furnish revised document.
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<b>d. TITLE</b>		<b>e. SIGNATURE</b>				
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<b>9. TITLE OF DOCUMENT</b> <b>DETAIL SPEC FUZE, HAND GRENADE M213</b>		<b>10. REVISION LETTER</b> a. CURRENT -	b. NEW  <b>11. ECP NO.</b>
<b>12. CONFIGURATION ITEM (OR SYSTEM) TO WHICH ECP APPLIES</b> <b>FUZE, HAND GRENADE M213 ASSEMBLY</b>			<b>SHT 1 OF 2</b>
<b>13. DESCRIPTION OF REVISION</b>  <b>DTL 8822131, DATED 24 JULY 2001</b>  <b>PAGE 24, PARAGRAPH 4.3.2.11, CHANGE:</b>  <b>FROM: "1 Any crack or porosity in the fuze body 100% 3.5 4.3.3.1"</b> <b>TO: "108 Any crack or porosity in the fuze body 100% 3.5 4.3.3.1"</b>  <b>PAGE 25, PARAGRAPH 4.3.2.12, CHANGE:</b>  <b>FROM: "10 Delay column height, min 100% 3.3 4.3.3.3(a)"</b> <b>TO: "10 Delay column height, min 100% 3.3 4.3.3.3"</b>  <b>FROM: "2 Safety pin withdrawal lower limit (b) (b) 3.8 4.3.3.5"</b> <b>TO: "2 Safety pin withdrawal lower limit (a) (a) 3.8 4.3.3.5"</b>  <b>NOTE: DELETE: "(a) Alternate method of ... design agency."</b>  <b>NOTE: CHANGE:</b>  <b>FROM: "(b) See table V for sample size and accept/reject criteria."</b> <b>TO: "(a) See table V for sample size and accept/reject criteria."</b>			
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<b>9. TITLE OF DOCUMENT</b> <b>DETAIL SPEC FUZE, HAND GRENADE M213</b>		<b>10. REVISION LETTER</b> a. CURRENT -	
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<b>13. DESCRIPTION OF REVISION</b>  <p><b>DTL 8822131, DATED 24 JULY 2001</b></p> <p><b>PAGE 41, ADD THE FOLLOWING:</b></p> <p><b>"6.12 VOID OR CRACK (CRITICAL DEFECT).</b> This characteristic applies to the delay composition after it has been loaded in accordance with note 2 of drawing 8822131. This Critical I Defect is defined by any inclusion having a volume greater than <math>3.10 \times 10^{-5}</math> cubic inches in the stem of the Fuze Body, drawing 8822132, or greater than <math>5.40 \times 10^{-5}</math> cubic inches in the threaded region when using automated Digital X-Ray inspection equipment. Alternatively, this Critical I Defect is defined by any inclusion having an area greater than <math>1.25 \times 10^{-3}</math> square inches in the stem of the Fuze Body or greater than <math>1.96 \times 10^{-3}</math> square inches in the threaded region when using hard plate X-Ray equipment for inspection."</p> <p><b>"6.13 CRACK OR POROSITY IN THE FUZE BODY(MAJOR DEFECT).</b> This characteristic applies to the fuze body casting outer surface after it has been manufactured in accordance with drawing 8822132. A Crack or Porosity in the fuze body is classified as a Major Defect when any intrusion has either length, width or depth of greater than .02 inches on the outer surface of the fuze body."</p>			
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a. (X one)	<input checked="checked" type="checkbox"/> X  <input type="checkbox"/>  <input type="checkbox"/>	(1) Existing document supplemented by this NOR may be used in manufacture. (2) Revised document must be received before manufacturer may incorporate this change. (3) Custodian of master document shall make above revision and furnish revised document.	
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		7. CAGE CODE <b>19200</b>	
9. TITLE OF DOCUMENT <b>DETAIL SPEC FUZE, HAND GRENADE M228</b>		10. REVISION LETTER	
		a. CURRENT -	
		b. NEW	
12. CONFIGURATION ITEM (OR SYSTEM) TO WHICH ECP APPLIES <b>FUZE, HAND GRENADE M228 ASSEMBLY</b>		11. ECP NO.	
		<b>SHT 1 OF 2</b>	
13. DESCRIPTION OF REVISION			
<p><b>DTL 9235210, DATED 6 AUG 2001</b></p> <p><b>PAGE 24, PARAGRAPH 4.3.2.11, CHANGE:</b></p> <p><b>FROM: "1 Any crack or porosity in the fuze body 100% 3.5 4.3.3.1"</b>  <b>TO: "108 Any crack or porosity in the fuze body 100% 3.5 4.3.3.1"</b></p> <p><b>PAGE 25, PARAGRAPH 4.3.2.12, CHANGE:</b></p> <p><b>FROM: "10 Delay column height, min 100% 3.3 4.3.3.3(a)"</b>  <b>TO: "10 Delay column height, min 100% 3.3 4.3.3.3"</b></p> <p><b>FROM: "2 Safety pin withdrawal lower limit (b) (b) 3.8 4.3.3.5"</b>  <b>TO: "2 Safety pin withdrawal lower limit (a) (a) 3.8 4.3.3.5"</b></p> <p><b>NOTE: DELETE: "(a) Alternate method of ... design agency."</b></p> <p><b>NOTE: CHANGE:</b></p> <p><b>FROM: "(b) See table V for sample size and accept/reject criteria."</b>  <b>TO: "(a) See table V for sample size and accept/reject criteria."</b></p>			
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<b>NOTICE OF REVISION (NOR)</b> THIS REVISION DESCRIBED BELOW HAS BEEN AUTHORIZED FOR THE DOCUMENT LISTED		1. DATE (YYYYMMDD) <b>20021210</b>	Form Approved OMB No. 0704-0188
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		5. CAGE CODE <b>19200</b>	6. NOR NO. <b>0004</b>
4. ORIGINATOR a. TYPED NAME (First, Middle Initial, Last) <b>Douglas A. Lincoln</b>	b. ADDRESS (Street, City, State, Zip Code) <b>TACOM-ARDEC, AMSTA-AR-FSA-RF          Rock Island, IL 61299-7300</b>	7. CAGE CODE <b>19200</b>	8. DOCUMENT NO. <b>DTL 9235210</b>
9. TITLE OF DOCUMENT <b>DETAIL SPEC FUZE, HAND GRENADE M228</b>		10. REVISION LETTER a. CURRENT -	11. ECP NO.
12. CONFIGURATION ITEM (OR SYSTEM) TO WHICH ECP APPLIES <b>FUZE, HAND GRENADE M228 ASSEMBLY</b>		SHT 2 OF 2	
13. DESCRIPTION OF REVISION  <div style="margin-left: 40px;"> <b>DTL 9235210, DATED 6 AUG 2001</b>   <b>PAGE 41, ADD THE FOLLOWING:</b>   <p>“6.12 VOID OR CRACK (CRITICAL DEFECT). This characteristic applies to the delay composition after it has been loaded in accordance with note 2 of drawing 9235210. This Critical I Defect is defined by any inclusion having a volume greater than <math>3.10 \times 10^{-5}</math> cubic inches in the stem of the Fuze Body, drawing 8822132, or greater than <math>5.40 \times 10^{-5}</math> cubic inches in the threaded region when using automated Digital X-Ray inspection equipment. Alternatively, this Critical I Defect is defined by any inclusion having an area greater than <math>1.25 \times 10^{-3}</math> square inches in the stem of the Fuze Body or greater than <math>1.96 \times 10^{-3}</math> square inches in the threaded region when using hard plate X-Ray equipment for inspection.”</p> <p>“6.13 CRACK OR POROSITY IN THE FUZE BODY(MAJOR DEFECT). This characteristic applies to the fuze body casting outer surface after it has been manufactured in accordance with drawing 8822132. A Crack or Porosity in the fuze body is classified as a Major Defect when any intrusion has either length, width or depth of greater than .02 inches on the outer surface of the fuze body.”</p> </div>			
14. THIS SECTION FOR GOVERNMENT USE ONLY			
a. (X one)	X	(1) Existing document supplemented by this NOR may be used in manufacture. (2) Revised document must be received before manufacturer may incorporate this change. (3) Custodian of master document shall make above revision and furnish revised document.	
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d. TITLE	e. SIGNATURE	f. DATE SIGNED (YYYYMMDD)	
15.a. ACTIVITY ACCOMPLISHING REVISION	b. REVISION COMPLETED (SIGNATURE)	c. DATE SIGNED (YYYYMMDD)	



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		<b>7. CAGE CODE</b> <b>19200</b>	<b>8. DOCUMENT NO.</b> <b>MIL-G-14933 AMD 3</b>			
<b>9. TITLE OF DOCUMENT</b> <b>MIL SPEC HAND GRENADE M67 LOADING</b>		<b>10. REVISION LETTER</b> a. CURRENT <b>B</b>				
		b. NEW				
<b>11. ECP NO.</b>						
<b>12. CONFIGURATION ITEM (OR SYSTEM) TO WHICH ECP APPLIES</b> <b>HAND GRENADE M67</b>						
<b>SHT 1 OF 2</b>						
<b>13. DESCRIPTION OF REVISION</b>  <p><b>PAGE 4, PARAGRAPH 3.8.d CHANGE:</b></p> <p><b>FROM: "d. Voids at bottom of delay column (Major Defect)"</b>  <b>TO: "d. Voids or Cracks In delay column (Critical Defect)"</b></p> <p><b>PAGE 4, PARAGRAPH 3.8.e: DELETE PARAGRAPH IN ITS ENTIRETY.</b></p> <p><b>PAGE 22, PARAGRAPH 6.7.2: DELETE PARAGRAPH IN ITS ENTIRETY.</b></p> <p><b>PAGE 22, PARAGRAPH 6.7.3: DELETE PARAGRAPH IN ITS ENTIRETY AND REPLACE WITH THE FOLLOWING:</b></p> <p><b>"6.7.3 VOID OR CRACK IN DELAY COLUMN(CRITICAL DEFECT). This characteristic applies to the delay composition after it has been loaded in accordance with note 2 of drawing 8822131. This Critical Defect is defined by any inclusion having a volume greater than <math>3.10 \times 10^{-5}</math> cubic inches in the stem of the Fuze Body, drawing 8822132, or greater than <math>5.40 \times 10^{-5}</math> cubic inches in the threaded region. Alternatively, this Critical Defect is defined by any inclusion having an area greater than <math>1.25 \times 10^{-3}</math> square inches in the stem of the Fuze Body or greater than <math>1.96 \times 10^{-3}</math> square inches in the threaded region when using hard plate X-Ray equipment for inspection."</b></p> <p><b>PAGE 22, PARAGRAPH 6.7.4: DELETE PARAGRAPH IN ITS ENTIRETY.</b></p>						
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<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 10%;">a. (X one)</td> <td style="width: 10%; text-align: center;">X</td> <td style="width: 80%;">           (1) Existing document supplemented by this NOR may be used in manufacture.            (2) Revised document must be received before manufacturer may incorporate this change.            (3) Custodian of master document shall make above revision and furnish revised document.         </td> </tr> </table>				a. (X one)	X	(1) Existing document supplemented by this NOR may be used in manufacture. (2) Revised document must be received before manufacturer may incorporate this change. (3) Custodian of master document shall make above revision and furnish revised document.
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<b>9. TITLE OF DOCUMENT</b> <b>MIL SPEC HAND GRENADE M67 LOADING</b>		<b>10. REVISION LETTER</b> a. CURRENT <b>B</b>	
		b. NEW	
<b>12. CONFIGURATION ITEM (OR SYSTEM) TO WHICH ECP APPLIES</b> <b>HAND GRENADE M67</b>		<b>SHT 2 OF 2</b>	
<b>13. DESCRIPTION OF REVISION</b>  <b>PAGE 23, CHANGE:</b>  <b>FROM: "6.7.5 Porosity in the fuze body (Major Defect) - ... found to be porous."</b> <b>TO: "6.7.4 Porosity in the fuze body (Major Defect) - ... found to be porous."</b>  <b>PAGE 23, PARAGRAPH 6.7.6: DELETE PARAGRAPH IN ITS ENTIRETY.</b>  <b>PAGE 23, PARAGRAPH 6.7.7: DELETE PARAGRAPH IN ITS ENTIRETY.</b>			
<b>14. THIS SECTION FOR GOVERNMENT USE ONLY</b>			
a. (X one)	<input checked="checked" type="checkbox"/> X  <input type="checkbox"/>  <input type="checkbox"/>	(1) Existing document supplemented by this NOR may be used in manufacture. (2) Revised document must be received before manufacturer may incorporate this change. (3) Custodian of master document shall make above revision and furnish revised document.	
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